

Date: Tuesday, 3/11/2008 10:28:29 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PEDAL ASSEMBLY
Job Number	: 37775	Part Number	: D3204041
Estimate Number	: 10504	Drawing Number	: D3204 REV. A1
P.O. Number	:	Project Number	: N/A
This Issue	: 3/11/2008 S.O. No. :	Drawing Revision	: A1
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : LARGE FAB ASSY	Due Date	: 4/4/2008
Previous Run	: 37169	Qty:	4 Um: Each
Written By	:		
Checked & Approved By	: <u>JS 080311</u>		
Comment	: Est:C 05.08.11 Added Step 25 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D32041	Tube
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Tube

Pick:

Qty	Part Number	Description	Batch
1	D3204-1	Tube	B 35873

JS 08/04/01

2.0	D32043	Arm
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Arm

Pick:

Qty	Part Number	Description	Batch
1	D3204-3	Arm	B 37245

JS 08/04/01

3.0	D32045	Arm
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Arm

Pick:

Qty	Part Number	Description	Batch
1	D3204-5	Arm	B 35876

JS 08/04/01

4.0	D32049	Pedal
-----	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pedal

Pick:

Qty	Part Number	Description	Batch
1	D3204-9	Pedal	B 35877

JS 08/04/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: PEDAL ASSEMBLY

Job Number: 37775

Part Number: D3204041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D320411

Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Plate

Pick:

Qty Part Number Description  
1 D3204-11 Plate

Batch

✓  
B35874

JS 08/04/01

6.0

D320413

Gusset



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Gusset

Batch: B35970

✓

JS 08/04/01

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per Dwg D3204 using Jig D3204-041T1. ✓

2- Drill #40 diameter hole in the center of Ø0.760" c'bore on D3204-5 arm prior to weld. ✓

3- Use JB weld compound to plug the hole after assembly. ✓

4- Grind JB weld flush after it is cured. ✓

Identify as D3204-041

JS 08/04/02 (3x)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

JS 08/04/02 (3)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JS 08/04/02 (x3)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-1 07/04/03

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

\*\*\*Cover holes for bushing\*\*\*

M 106442 (3) BR 08-04-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Drawing Name: PEDAL ASSEMBLY

Job Number: 37775

Part Number: D3204041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 08/04/04 (3)

13.0

D32047

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Pick:

Qty Part Number

Description

Batch

2 D3204-7

Bushing

5+ B24722 1, B35632

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install D3204-7 bushing as shown in Dwg D3204

EB 08/04/07 (3)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6 08/06/07 (13)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

84/9 300 (3X)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/08

Job Completion



W 08/04/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

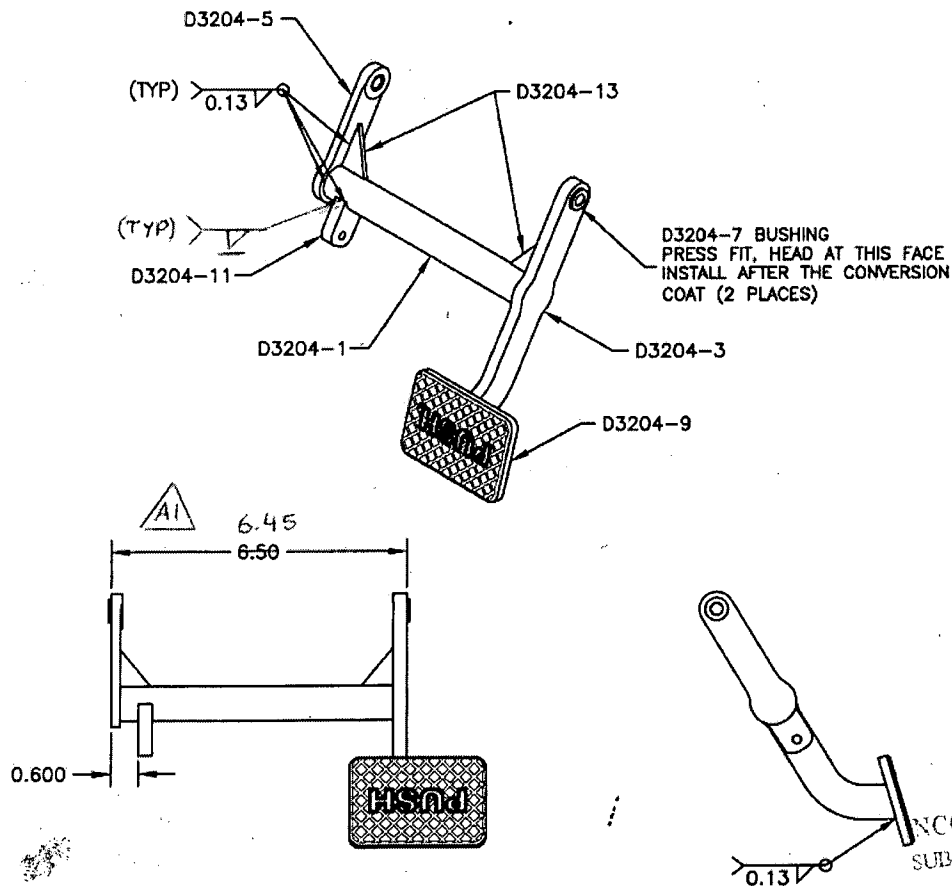
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

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CHECKED #	APPROVED #	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS	
A	04.01.27	NEW ISSUE	
AI	05.07.15	6.45 WAS 6.50	

**RELEASED**  
04.04.30



**D3204-041 RELEASE PEDAL ASSEMBLY**

**NOTES**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020  
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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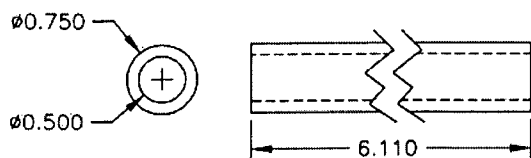
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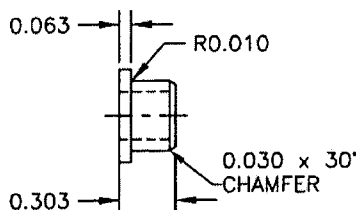


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DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

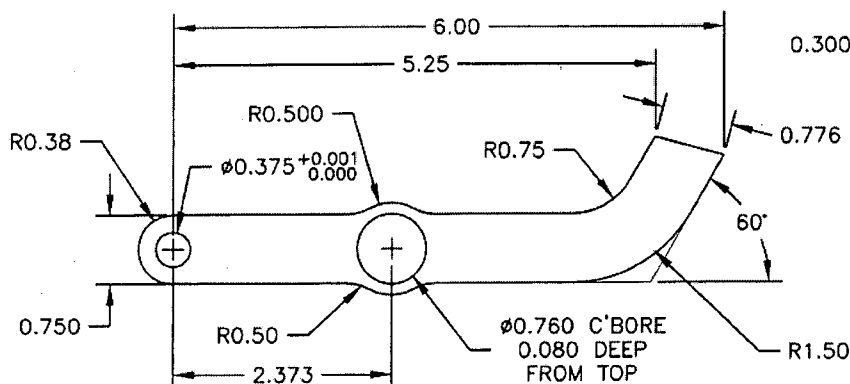
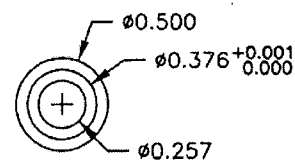
RELEASED  
04.04.05 #



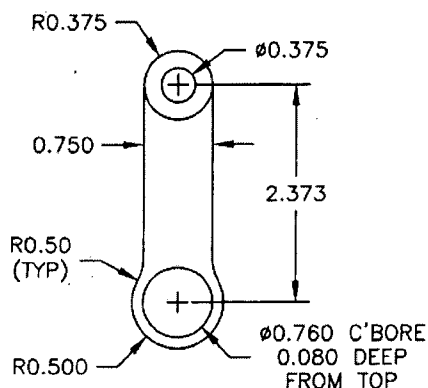
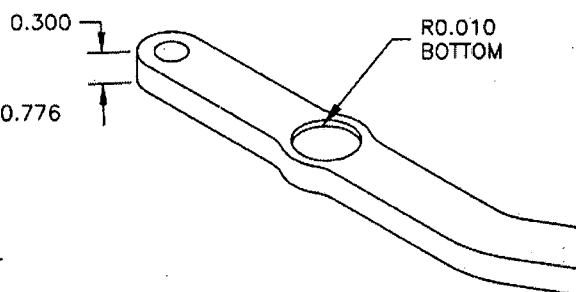
2 D3204-1 TUBE  
SCALE 1:2



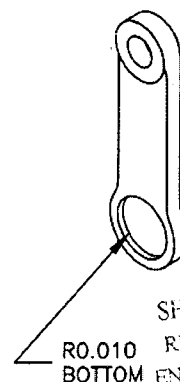
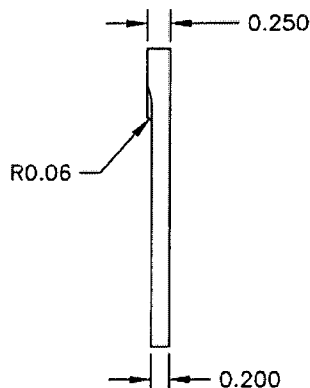
4 D3204-7 BUSHING  
SCALE 1:1



3 D3204-3 ARM  
SCALE 1:2



3 D3204-5 ARM  
SCALE 1:2



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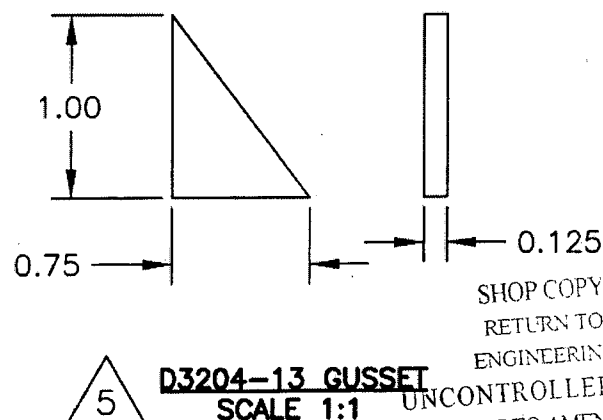
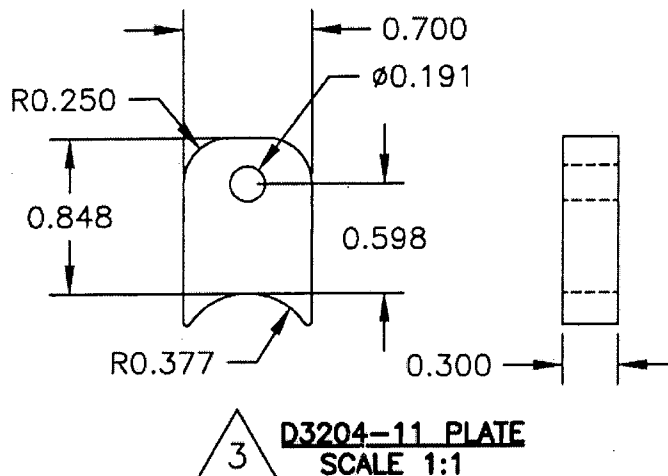
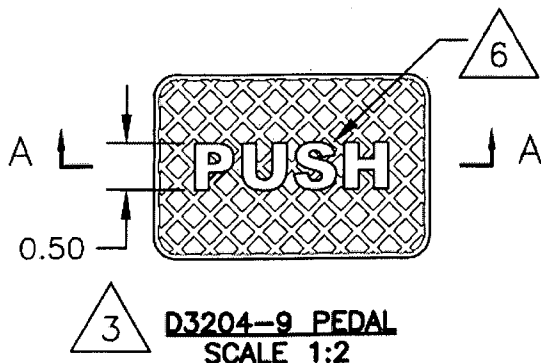
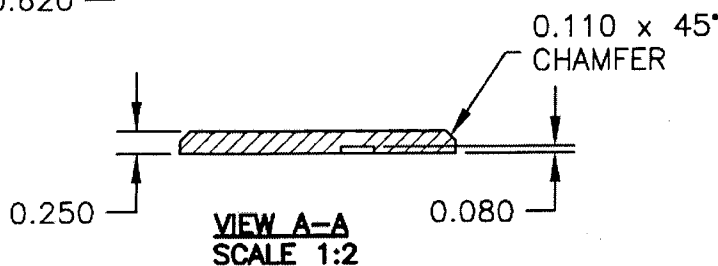
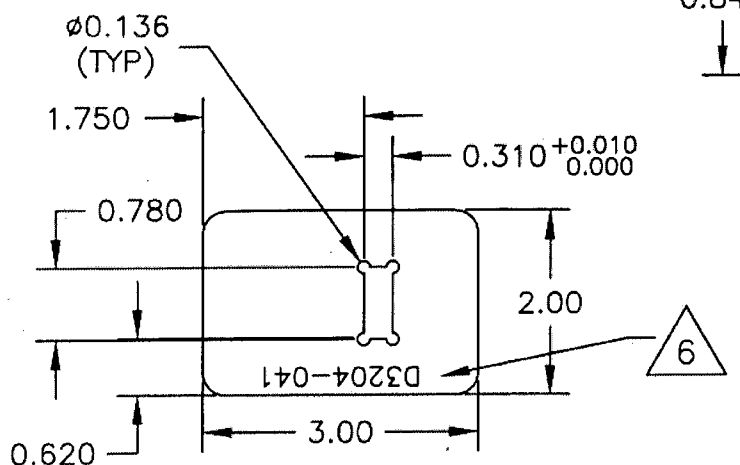
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04.04.30



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